



Cylinder Head Machining Option for 1998-20016 Volvo D12 & D13 Diesel Engines

The AERA Technical Committee offers the following information concerning the possibility of surfacing 1998-2016 Volvo D12 and D13 diesel cylinder heads. The SOHC design of these engines limits the possibility of surfacing the cylinder head deck without providing for a means of adjusting the gear to gear backlash.

The camshaft design of these heads incorporates individual camshaft towers to mount the camshaft to the cylinder head. Spacing those towers away from the cam idler gear after machining the cylinder head deck will maintain the proper gear to gear backlash.

It has been reported that the Innovative Machine Supply Company is now providing .020" (.500 MM) shims to properly position the camshaft for the above mentioned engines. To allow use of these shims the cylinder head deck surface will have to be machined .020" (.500 MM) from the new head thickness of 5.315" (135.000 MM). The company may be reached by either calling them at 636-825-3335 or contacting their website <http://www.innomach.com/home>.